

Date: Sunday, 12/4/2005 12:47:03 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 BASKET BASE (SHORT)
Job Number : 25093A	
Estimate Number : 10209	
P.O. Number : N/A	Part Number : D3265041
This Issue : 12/4/2005 S.O. No. : N/A	Drawing Number : D3265 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 23714A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/20/2006 Qty: 1 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est Rev:C Re-Format 05-11-03 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Qty 3 D3166-1 Basket Hoop Batch: B 25896

AA 06/06/05

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s)  
 3/4" x 3/4" x 0.063" wall 304/316 SS tubing.  
 (M304TS0.750W.065)  
 Batch: M10111

AA 06/06/05

3.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Pick:

Qty Part Number	Description	Batch
2 D2232-3	Hinge bracket	<u>B 24527</u>

AA 06/06/06

4.0	D2325	Support Gusset (350 Bask
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Pick:

Qty Part Number	Description	Batch
4 D2325	Support Gusset	<u>B 26922</u> x1 <u>B 26749</u> x3

AA 06/06/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B25823

AA 06/06/06

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B26204

AA 6/6/06

7.0

D34425

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3442-5

Shim

B24246

AA 6/6/06

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

26sf

M304EX0.75-16F Expanded Metal

M100981

AA 06/06/07

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

AA 06/06/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION

PD 06-06-07



Comment: DDIMENSIONAL & WELDING INSPECTION

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/22 (1)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with White Sikaflex-291

Batch: M101193

Expiry date: 11/06

SB

06/06/23

13.0

QC3

.INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/06/23

Job Completion



Inspection level 21 SB 06/06/28 (1)  
U 06-06-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Job Number:



Seq. No.	Machine or Operation	Description
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 4 AN970-4 Washer	
23.0	MS20600AD4W3	Cherry Rivets
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 2 MS20600AD4W3 Rivet	
24.0	MS21042L3	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 2 MS21042L3 Nut (or -3)	
25.0	MS21042L4	Nut
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 4 MS21042L4 Nut (or -4)	
26.0	MS21042L5	Nut
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 4 MS21042L5 Nut (or -5)	
27.0	SMALL FAB 2	SMALL & MEDIUM FABRICATION RESOURCE 2
	Comment: SMALL & MEDIUM FABRICATION RESOURCE 2	
28.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
29.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick: Packing Kit	
30.0	D22301	Mounting Lug
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Packing Kit Qty Part Number DescriptionBatch 4 D2230-1 Lug	